

**Work Order ID 96527**

Tuesday, January 29, 2013 1:45:56 PM

**\*96527\***

HAI

Page 1

Item ID: D4576-3

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Stop Collar

Start Date: 1/29/2013 Start Qty: 6.00

**\*6\***

Cust Item ID:

Required Date: 2/4/2013 Req'd Qty: 6.00

**\*6\***

Customer:

Reference:

Approvals:

Process Plan: *MK*Date: *13-1-29*

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D4576

C

100

0.00

**\*100\***

Lathe Conv

Memo

0.00

Conventional Lathe

TURN AS PER DWG

*13-02-06**6**0*

105

0.00

**\*105\***

Mill Conv

Memo

0.00

Conventional Milling Machine

DRILL HOLE AS PER DWG

*MP 13/02/07**6**6*

110

QC2- Inspect parts off machine FAI/FAIB

0.00

**\*110\***

QC

Memo

0.00

Quality Control

*13-02-06**6**0**MP 13/02/07**(Signature)*

# Work Order ID 96527

**\*96527\***

Page 2

Tuesday, January 29, 2013 1:45:56 PM

Item ID: D4576-3 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: Stop Collar  
Start Date: 1/29/2013 Start Qty: 6.00 **\*6\*** Cust Item ID:  
Required Date: 2/4/2013 Req'd Qty: 6.00 **\*6\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							
<b>*120*</b>									
QC	Memo	0.00				6	0		
Quality Control									
130	Identify as per dwg & Stock Location: <i>Medfab</i>	0.00							
<b>*130*</b>									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
<b>*140*</b>									
QC	Memo	0.00							
Quality Control									

*MF*  
*13-3-7*

# Picklist Print

Tuesday, January 29, 2013 1:45:55 PM

Page 1

Work Order ID: 96527

Parent Item: D4576-3

Start Date: 1/29/2013

Required Date: 2/4/2013

Parent Item Name: Stop Collar

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A NEW ISSUE 12-01-12 JLM VERIFIED BY:DD  
rev.C DD VERF:JLM IPP REV:B 12.10.15 as per dwg

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304R.500 304 SS roundbar .500		Purchased	No				f	41.2330		0.3410526			

.417 13-02-06

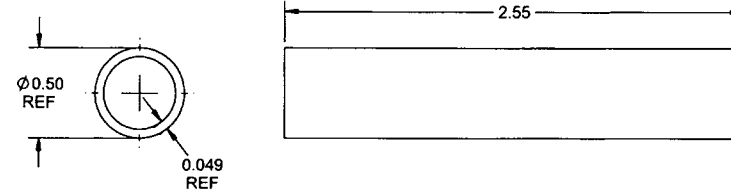
Location	Loc Qty	Loc Code
MAT029	41.233	
115334	18.27	
117890	22.963	

.417

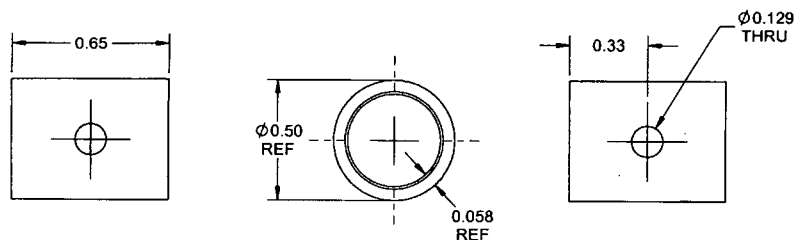
## FIRST ARTICLE INSPECTION CHECKLIST

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15



**D4576-5 FORWARD PLATE GUIDE**



**D4576-3 STOP COLLAR**

**NOTES:**

1) MATERIAL: AISI 304/316 STAINLESS STEEL SEAMLESS ROUND TUBING  
PER ASTM A213 OR ASME SA213 OR ASTM A269  
D4576-3: 0.500 O.D. X 0.058 WALL  
REF. DART SPEC M304TR0.500W.058  
D4576-5: 0.500 O.D. X 0.049 WALL  
REF. DART SPEC M304TR0.500W.049

2) FINISH: N/A  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: PER DART QSI 044 6.6 OR 6.7  
7) WEIGHT: - D4576-3 = 0.01 lbs ea.  
- D4576-5 = 0.06 lbs

RELEASE  
2012-09-26

DESIGN	RP	<b>DART AEROSPACE LTD</b>	
DRAWN	RP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	A.P.	DRAWING NO.	REV. C
MFG. APPR.		D4576	SHEET 8 OF 12
APPROVED		TITLE	SCALE
DE APPR.		HORIZONTAL LINKAGE ASSY	NTS
DATE	12.09.11	<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	